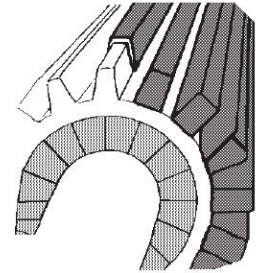


Tough build-up alloy for steels offering superior compression and impact resistance



- Excellent operation on low voltage AC machines.
- Deposits easy to machine tough weldments.
- All position capabilities allows for cladding in position.
- Straight polarity (DC-) option doubles build-up speed.

INTERNATIONAL SPECIFICATIONS

NONE APPLICABLE TO THIS PROPRIETARY PRODUCT

APPLICATIONS:

Build-up and cladding of carbon and low alloy steels. Heavy thicknesses will not crack.

MICROSTRUCTURE:

In the as-deposited condition, the microstructure consists of martensite with some carbides.

ALL WELD METAL ANALYSIS (Typical Weight %):

C	Mn	Si	P	S	Cr	Ni	Mo	V	W	Cb	Fe
.29	2.37	.61	.012	.016	1.0	.08	.03	.03	.01	.01	bal

FLUX COLOR: Dark grey

TYPICAL MECHANICAL PROPERTIES:**Undiluted Weld Metal**

Hardness

Maximum Value Up to:

Rockwell C33-38

Brinell 310-350

Vickers 340-380

RECOMMENDED CURRENT: DC Reverse (+), Straight (-) or AC**RECOMMENDED AMPERAGE SETTINGS:**

Diameter (mm)	1/8 (3.25)	5/32 (4.0)	3/16 (5.0)
Minimum Amperage	90	120	160
Maximum Amperage	110	140	180

WELDING POSITIONS: Flat, Vertical up, Horizontal, Overhead**DEPOSITION RATES:**

Diameter (mm)	Length (mm)	Weldmetal/ Electrode	Electrodes per lb (kg) of Weldmetal	Arc Time of Deposition min/lb (kg)	Amperage Setting
1/8 (3.25)	14" (350)	.59oz (17g)	27 (60)	21 (47)	115
5/32 (4.0)	14" (350)	1.1oz (30g)	15 (32)	18 (39)	175
3/16 (5.0)	14" (350)	1.8oz (50g)	9 (20)	13 (28)	220

WELDING TECHNIQUES:

Remove fatigued metal. Weld deposits can be made using stringer or weave technique. For very high build-ups use DC straight polarity (-).